

Work Order ID **76268****\*76268\*****U/R**

Page 1

Tuesday, November 08, 2011 1:25:08 PM

Item ID: D3564-11

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Wearshoe

Start Date: 11/8/2011 Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 11/22/2011 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Run Start **\*NR1\***

Approvals:

Process Plan: M.L.JDate: 11/11/08

Tooling:

Date:

Stop **\*NR2\***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3564

Rev D U/R

OK of 11/11/09

0.00

100

**\*100\***

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3564 \*\*\*\*\* (D3564-1F) \*\*\*\*\* Dwg Rev: 4/2 Prog  
Rev: 4/2 2-Deburr if necessaryDB11-11-14(12)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Memo

0.00

Quality Control

B11-11-14

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

Quality Control

Deburr(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 76268

**\*76268\***

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Tuesday, November 08, 2011 1:25:08 PM

Item ID: D3564-11 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Wearshoe  
 Start Date: 11/8/2011 Start Qty: 12.00 **\*12\*** Cust Item ID:  
 Required Date: 11/22/2011 Req'd Qty: 12.00 **\*12\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> Brake NC Brake NC	NC BRAKE  Memo Deburr if necessary	0.00 0.00				(12)			
140 <b>*140*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00				(42)			
150 <b>*150*</b> Large Fab Large Fab	Large Fab  Memo Qty Description Batch/A/R 2059B Hardcoat Weld hardcoat as per Dwg D3437	0.00 0.00				(12)			

8/11/12

5/11/12

(12) MAL/12 12/01/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*76268\***

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Tuesday, November 08, 2011 1:25:08 PM

Item ID: D3564-11 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Wearshoe  
 Start Date: 11/8/2011 Start Qty: 12.00 **\*12\*** Cust Item ID:  
 Required Date: 11/22/2011 Req'd Qty: 12.00 **\*12\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***  
 Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 <b>*160*</b> QC Quality Control	QC10- Inspect visual per QSI004- ground welds  Memo	0.00 0.00		51260113					
170 <b>*170*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00		51260113					(12)
180 <b>*180*</b> Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3  Memo START TIME: 10:50 FINISH TIME: 11:20	0.00 0.00							12X Ø M/L 12/04/17

M 118489

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*76268\***

Page 4

Tuesday, November 08, 2011 1:25:08 PM

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 Revision ID: Stop **\*NS2\***  
 Item Name: Wearshoe  
 Start Date: 11/8/2011 Start Qty: 12.00 **\*12\*** Cust Item ID:  
 Required Date: 11/22/2011 Req'd Qty: 12.00 **\*12\*** Customer:

Reference: Run Start **\*NR1\***  
 Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 <b>*190*</b> QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00							
200 <b>*200*</b> Packaging Packaging	Identify as per dwg & Stock Location: <u>F-P1</u>  Memo	0.00  0.00							
210 <b>*210*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							

12 ~~6~~ 12/01/17  
 courtesy measured

12x0 M-12/01/17

12/1/18

12-01-17  
 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries



# Picklist Print

Page 1

Tuesday, November 08, 2011 1:25:13 PM

Work Order ID: 76268

**\*76268\***

Parent Item: D3564-11

**\*D3564-11\***

Parent Item Name: Wearshoe

Start Date: 11/8/2011

Required Date: 11/22/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-03-08 ec  
 IPP Rev:B As per Rev C 07-07-09 JLM  
 IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC  
 IPP Rev:D Comments revised on Step 5, 6 per B44656 09-02-06 KJ  
 Verified By:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	126.3000	1.41	17.81053			

**\*M304S16GA\***

304/316 Sheet .063

\*\*

B11-11-14

Location

Loc Qty

Loc Code

MAT020

126.3

119346

126.3

119346

(Signature)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> <i>76248</i>
<b>Description:</b> Wearshoe		<b>Part Number:</b> D3564-11
<b>Inspection Dwg:</b> D3564	<b>Rev:</b> D	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.227	+/-0.010	3.229	2		V IB02	
2.432	+/-0.010	2.437	2		V	
2.50	+/-0.030	2.50	2		V	
6.000	+/-0.010	6.006	~		T IB01	
12.104	+/-0.010	12.104	x		T	
18.000	+/-0.010	18.000	1		T	
18.00	+/-0.030	18.00	~		T	
9.00	+/-0.030	9.00	x		T	
11.50	+/-0.030	11.50	x		T	
0.300 x 0.300	+/-0.010	303X 301	x		V	
Ø0.188	+0.005/-0.001	.190			V	
R0.375	+/-0.010	.375	2		R.G.	
0.063	+/-0.010	.060	x		V	

<b>Measured by:</b> <i>R</i>
<b>Date:</b> <i>11-11-14</i>

<b>Audited by:</b> <i>S</i>
<b>Date:</b> <i>11/11/15</i>

<b>Prototype Approval:</b>	N/A
<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	07.09.06	New Issue	KJ/JLM	
B	07.11.23	Dwg Rev updated	KJ/EC/DD	<i>[Signature]</i>

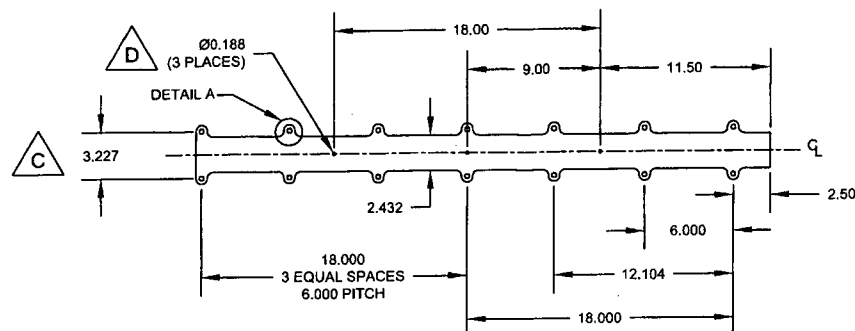
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

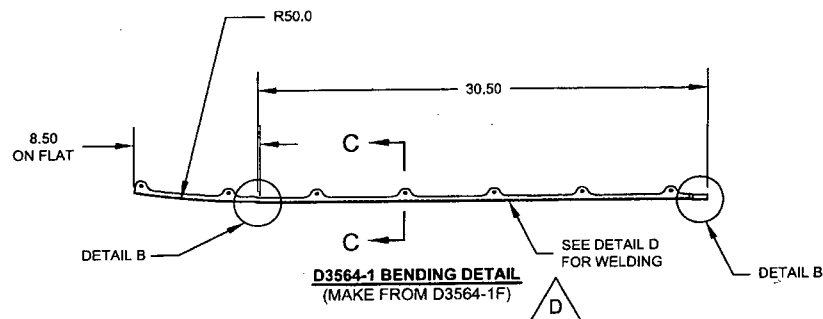
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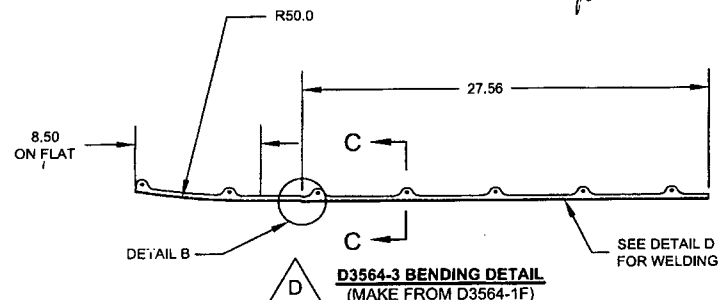
**NOTE:** Date & initial all entries



**D3564-1F FLAT PATTERN**



**D3564-1 BENDING DETAIL**  
(MAKE FROM D3564-1F)



**D3564-3 BENDING DETAIL**  
(MAKE FROM D3564-1F)

**D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT Q

**WEIGHTS:**

D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

SHOP  
RETURN  
ENGINE  
UNCONT  
SUBJECT  
WIT  
W  
NO. 76246  
11/11/00

RELEASED  
07.09.04

UNDER REVIEW  
11/11/00  
Fresh change

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5,C5: ADD D3564-15; PG1 B6,B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	CB		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.08.21		
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3564 TITLE WEARSHOE SCALE 1:8 REV. D SHEET 1 OF 3 COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

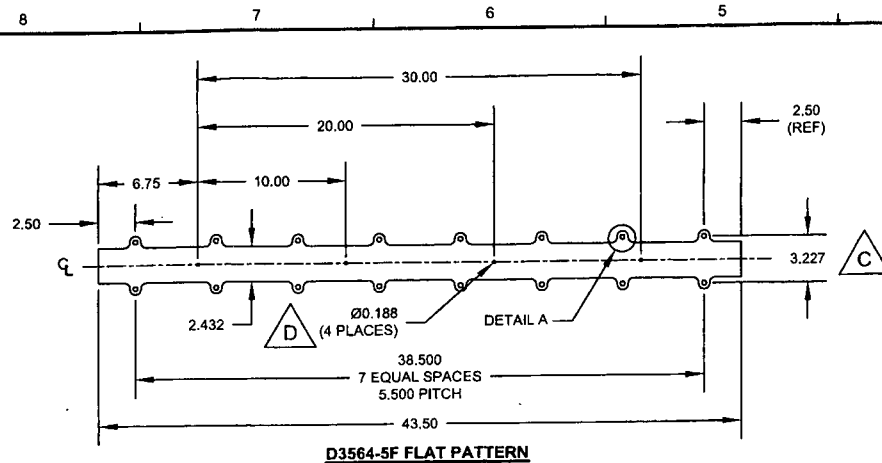
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

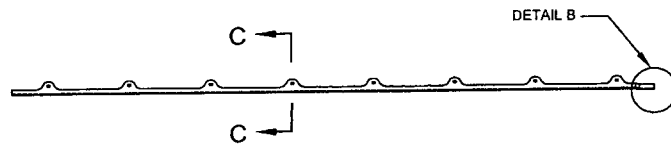
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

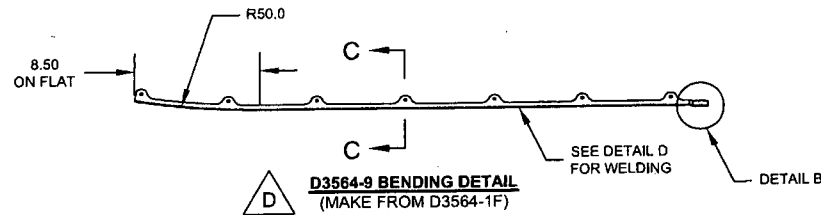
**NOTE:** Date & initial all entries



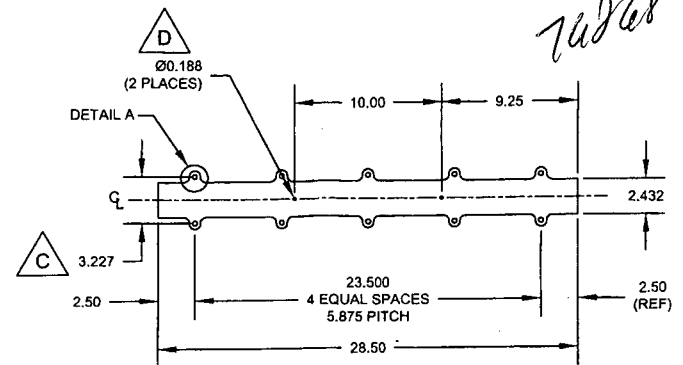
**D3564-5F FLAT PATTERN**



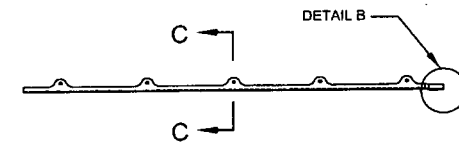
**D3564-5 BENDING DETAIL**  
(MAKE D3564-5 FROM D3564-5F)



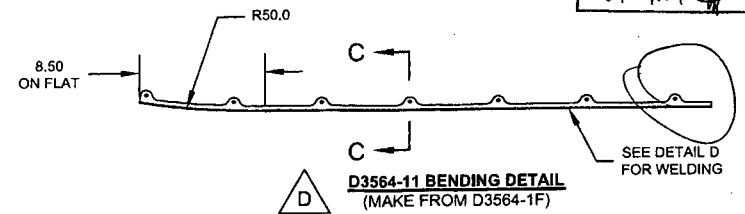
**D3564-9 BENDING DETAIL**  
(MAKE FROM D3564-1F)



**D3564-7F FLAT PATTERN**



**D3564-7 BENDING DETAIL**  
(MAKE D3564-7 FROM D3564-7F)



**D3564-11 BENDING DETAIL**  
(MAKE FROM D3564-1F)

RELEASED  
07.09.04

DESIGN	PH	<b>DART AEROSPACE LTD</b>	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

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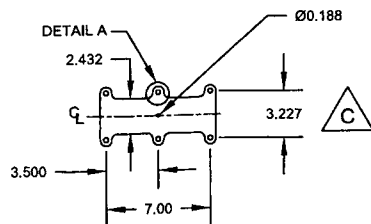
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

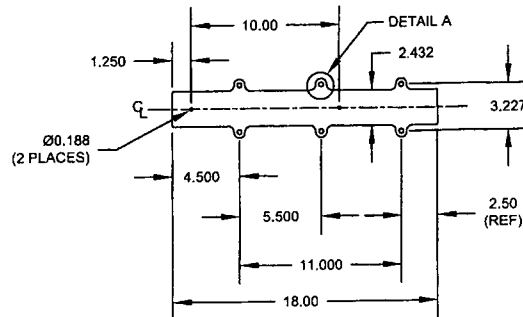
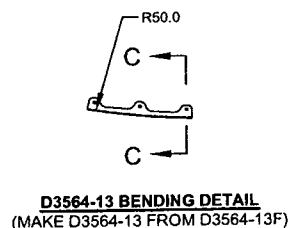
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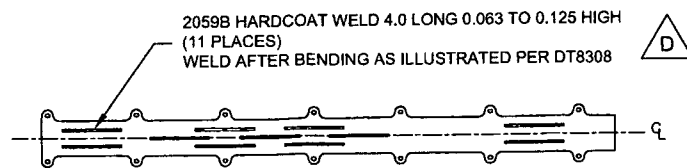
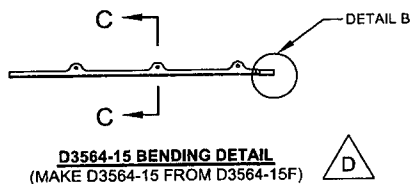




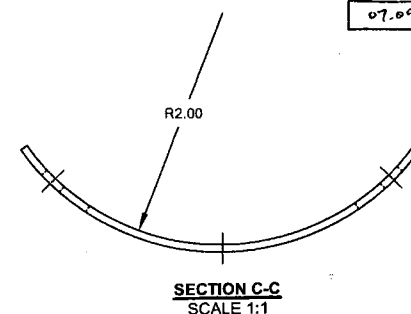
**D3564-13F FLAT PATTERN**



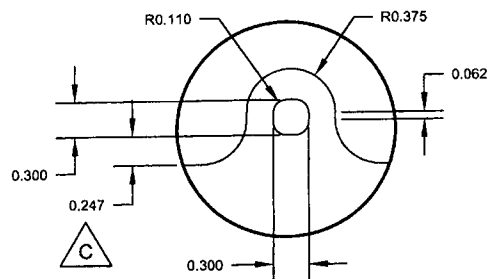
**D3564-15F FLAT PATTERN**



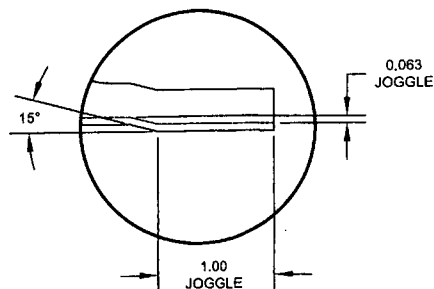
**DETAIL D**  
(D3564-1/-3/-9/-11 WELDING DETAIL)



**SECTION C-C**  
SCALE 1:1



**DETAIL A**  
SCALE 1:1



**DETAIL B**  
SCALE 1:1

**RELEASED**

07.09.04

UNDER REVIEW

DESIGN	PH	<b>DART AEROSPACE LTD</b>	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 3 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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